

D 4418-1

B 119148

A 20

Work Order ID 119148

\*119148\*

Page 1

May-12-14 7:34:36 AM

Item ID: D4418-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Step Lug

Start Date: 5/12/14 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 5/13/14 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan: ✓

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4418

A

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to 3.125"

10

0

JHL 2014-05-13

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB0063

DWG REV: 1A

FOLIO REV: 1A

2- deburr rough edges

10

0

JHL 2014-05-13

May-12-14 7:34:36 AM

Page 2

19-05-14

# Work Order ID 119148

**\*119148\***

Page 3

May-12-14 7:34:36 AM

Item ID: D4418-1 Accept **\*N19000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Lug  
 Start Date: 5/12/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 5/13/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145 <b>*145*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 128959 START: 3:10 OVEN T: 320 FINISH: 340.</i> Memo	0.00				10	0	14-5-21	DAS 34 9-89
146 <b>*146*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 DAS 27 9/89 14/5/23				10			
180 <b>*180*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>8T459A</i>  Memo	0.00				10x		14-5-23	DAS 26 9-89

Work Order ID 119148

\*119148\*

Page 4

May-12-14 7:34:36 AM

Item ID: D4418-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Step Lug

Start Date: 5/12/14 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 5/13/14 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

\*190\*

QC

Memo

0.00

Quality Control

MLJ 14-05-27

4-5-26

# Picklist Print

May-12-14 7:34:36 AM

Page 1

Work Order ID: 119148

**\*119148\***

Parent Item: D4418-1

**\*D4418-1\***

Parent Item Name: Step Lug

Start Date: 5/12/14

Required Date: 5/13/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 11-07-12 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.50 0		Purchased	No			100	f	1.1600	0.26	3			

**\*M6061T6B2 000X03 500\***

**\*\***

6061-T6 Bar 2.00 x 3.50

Location

Loc Qty

Loc Code

MAT009

1.16

125592

1.16

*QFS*  
*14/05/12*

*6061T6 2.5 x 3.5'*

*#126724*

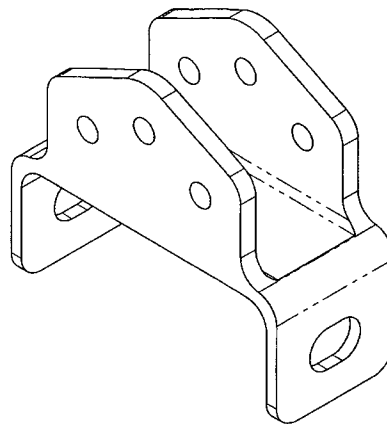
1.16'

1.33'



*Could not pull mat!*

1948



*who  
11/9/04*

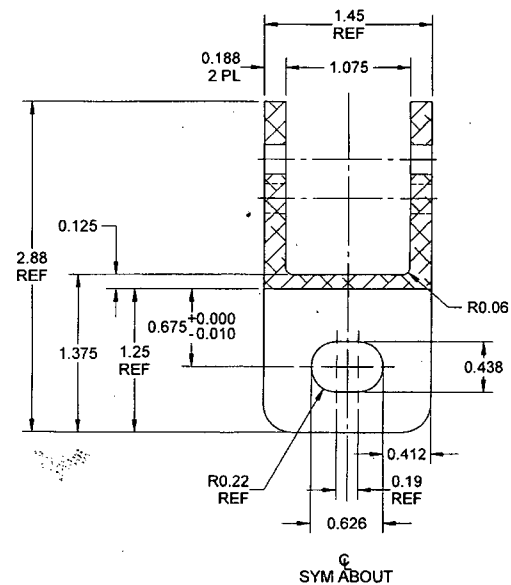
**D4418-1 STEP LUG**

**RELEASED**  
2011-07-28  
*AW*

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4418-1" AND B/N "BXXXXX"  
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.20 lbs

A		NEW ISSUE		AJS	11.07.04
REV.		DESCRIPTION		BY	DATE
DESIGN		AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN		AJS			
CHECKED		<i>Q</i>	DRAWING NO.	REV. A	
MFG. APPR.		<i>E</i>	<b>D4418</b>	SHEET 1 OF 2	
APPROVED		<i>AW</i>	TITLE	SCALE	
DE APPR.		<i>AW</i>	<b>STEP LUG</b>	NTS	
DATE	11.07.04	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



**SECTION A-A** C6-2

RELEASED  
2011-07-28

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4418</b>  TITLE <b>STEP LUG</b>  COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. A
DRAWN	JS		SHEET 2 OF 2
CHECKED	JS		SCALE
MFG. APPR.	JS		NTS
APPROVED	JS		
DE APPR.	JS		
DATE	11.07.04		



